

Work Order ID 132429

132429

Page 1

May-07-15 2:42:20 PM

Item ID: D4034-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Upper Rib Assembly
 Start Date: 5/07/15 Start Qty: 4.00 ***4/*** Cust Item ID:
 Required Date: 5/07/15 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: MAY 08 2015 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4034	C

100 Weld per dwg A/R S.S. rod Batch: B125054 0.00

100

Large Fab Memo 0.00
 Large Fab 1- Assemble ribs to hoop and weld as per dwg DT9564
 2- Weld bushing in rib and grind weld flush as per dwg

24 CC 15-6-15

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC Memo 0.00
 Quality Control

2 JUN 5 2015 DAS 24 9-09

120 QC5- Inspect part completeness to step on W/O 0.00

120

QC Memo 0.00
 Quality Control

2 JUN 5 2015 DAS 24 9-09

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: WA 4	0.00				2		JUN 15 2015	DAS 24 9-89
130									
Packaging	Memo	0.00							
Packaging	LOCATION: WA004								
140	QC21- Final Inspection - Work Order Release	0.00						JUN 15 2015	
140								MLJ	
QC	Memo	0.00							
Quality Control								MLJ	JUN 15 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER : _____																					

May-07-15 2:42:19 PM

Work Order ID: 132429

132429

Parent Item: D4034-041

D4034-041

Parent Item Name: Aft Upper Rib Assembly

Start Date: 5/07/15**Required Date:** 5/07/15

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP RevA: new issue DD 09.11.23 verified by:EC
per dwg revA 10.03.15 verified by:EC
DWG REV.B DD VRF:EC
REV.pc1 DD VRF:JLM
VRF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty per Kit On Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4034-1 *D4034-1* Rib		Manufactured	No			100	Each	8.0000	1	4			
				<u>Location</u> WA004 117170		<u>Loc Qty</u> 8 8		<u>Loc Code</u> B117480 → (2x)					
D4034-3 *D4034-3* Rib		Manufactured	No			100	Each	6.0000	1	4			
				<u>Location</u> WA004 127618		<u>Loc Qty</u> 6 6		<u>Loc Code</u> B129968 → (2x)					
D4021-7 *D4021-7* Hoop		Manufactured	No			100	Each	12.0000	1	4			
				<u>Location</u> WA004 129910 131878		<u>Loc Qty</u> 12 6 6		<u>Loc Code</u> → (2x)					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

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Page 2

Work Order ID: 132429

132429

Parent Item: D4034-041

D4034-041

Parent Item Name: Aft Upper Rib Assembly

Start Date: 5/07/15

Required Date: 5/07/15

Start Qty: 4.00

Required Qty: 4.00

D4021-9

Manufactured No

100

Each

116.0000

4

16

D4021-9

Bushing

CL 15-6-15

Location

WA004

120334

122601

123427

129869

130981

131842

Loc Qty

116

2

4

32

40

4

34

Loc Code

B116010 →

B132592 →

(1x)

(1x)

(6x)

2, Not in computer

DQA: _____ Date: _____



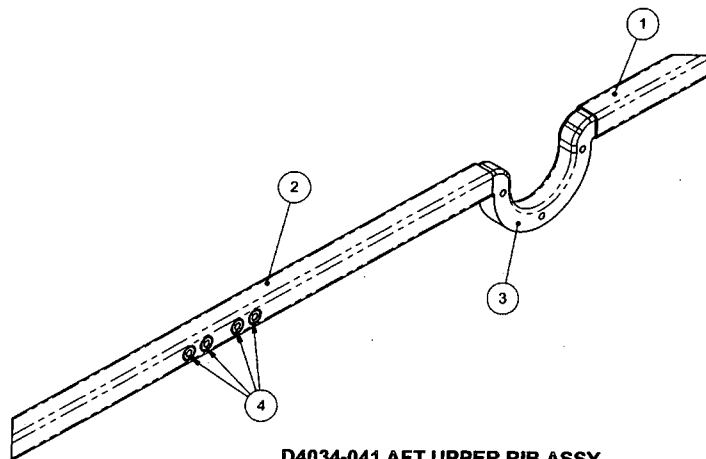
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

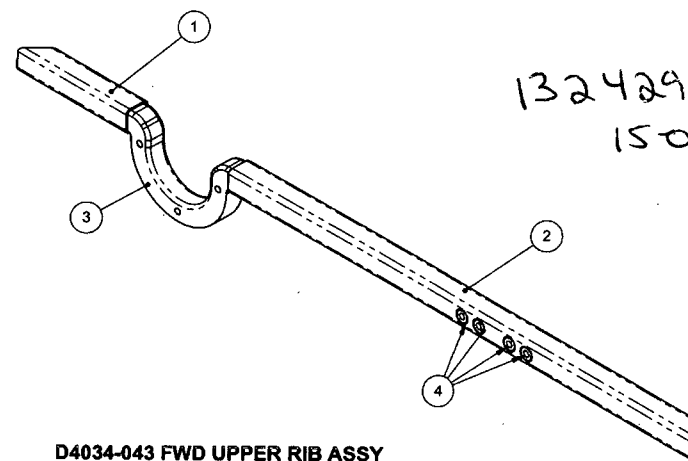
Work Order update only ☐

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OTHER :									

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1	1	D4034-3	RIB
3	1	1	D4021-7	HOOP
4	4	4	D4021-9	BUSHING



D4034-041 AFT UPPER RIB ASSY

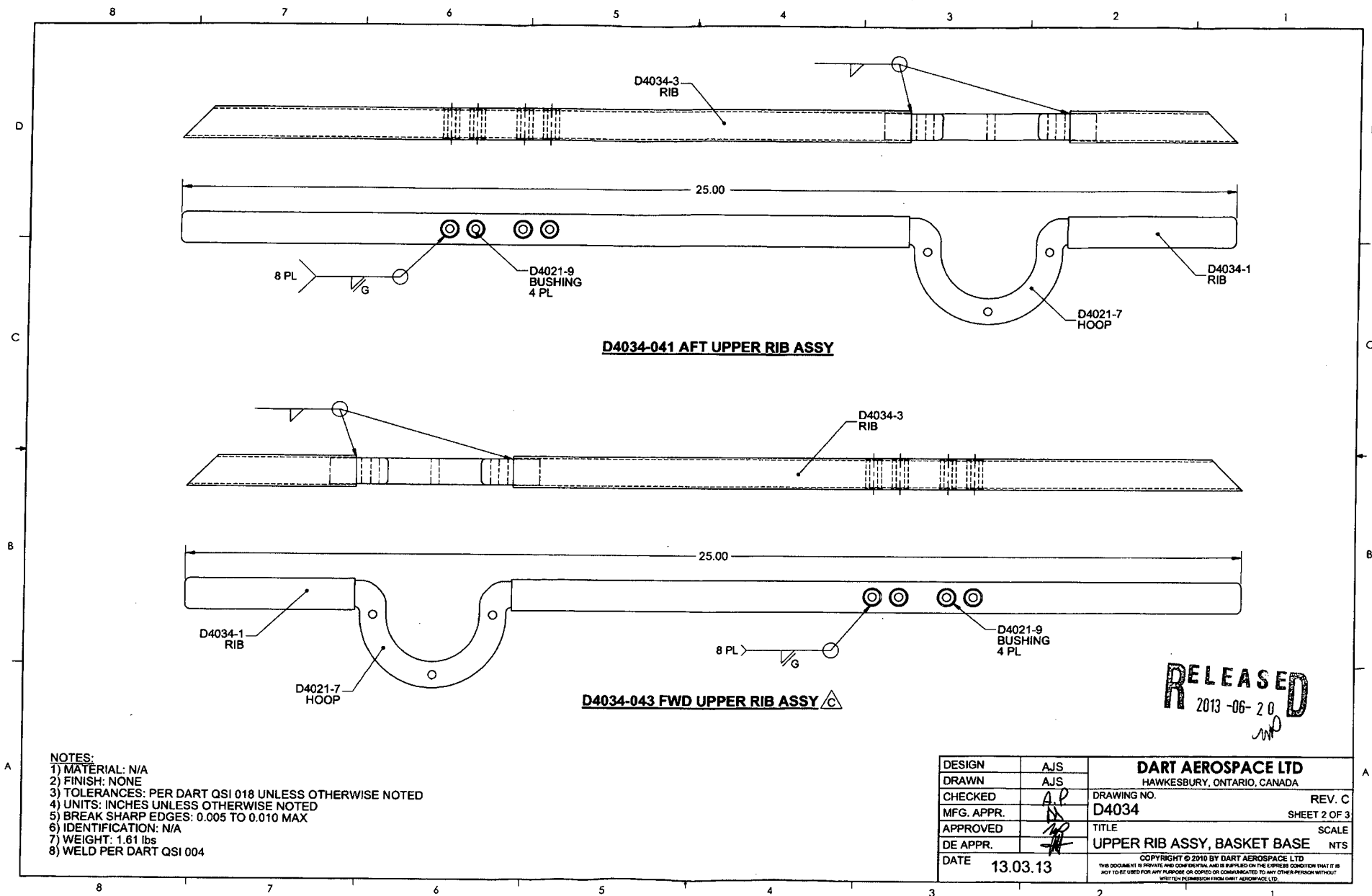


D4034-043 FWD UPPER RIB ASSY

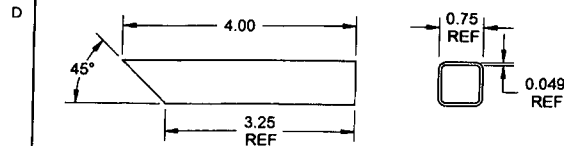
132429 MJS
15-05-08

RELEASED
2013-06-20

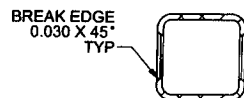
C	-043 REDESIGNED AS MIRROR IMAGE OF -041. -5 DELETED, D2327-3 DELETED, REASON PROP ARM NO LONGER OFFERED.		AJS	13.03.13
B	ADDITIONAL HOLES ADDED ON D4034-3 RIB		SC	10.12.20
A	NEW ISSUE		AJS	10.03.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4034 REV. C SHEET 1 OF 3 TITLE UPPER RIB ASSY, BASKET BASE NTS SCALE COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		
DRAWN	AJS			
CHECKED	A.P.			
MFG. APPR.	[Signature]			
APPROVED	[Signature]			
DE APPR.	[Signature]			
DATE	13.03.13			



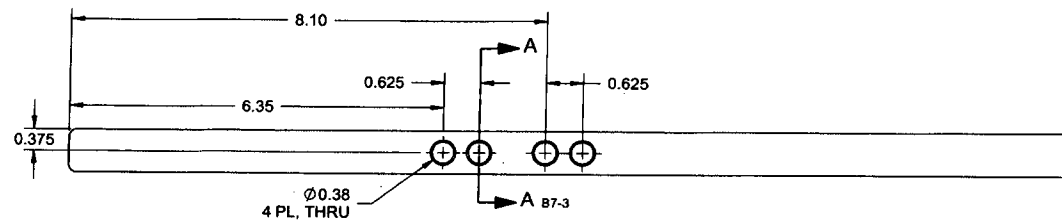
8 7 6 5 4 3 2 1



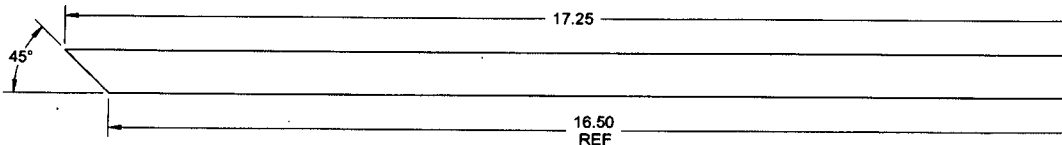
D4034-1 RIB



SECTION A-A C3-3



D4034-3 RIB



RELEASED
2013-06-28

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs
-3: 0.62 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AJS	DRAWING NO.	REV. C
MFG. APPR.	AJS	D4034	SHEET 3 OF 3
APPROVED	AJS	TITLE	SCALE
DE APPR.	AJS	UPPER RIB ASSY, BASKET BASE	NTS
DATE	13.03.13	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1